

Date: Tuesday, 07/04/2009 11:46:34 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	350 SKIDTUBE ASSEMBLY LH
Job Number :	47037		
Estimate Number :	10262		
P.O. Number :		Part Number :	D350636011
This Issue :	07/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2750 REV F
First Issue :	//	Project Number :	N/A
Previous Run :	47005	Drawing Revision :	F
	Type :	Material :	
	SKIDTUBES	Due Date :	30/04/2009
Written By :		Qty:	1 Um: Each
Checked & Approved By :	<u>JLD 09.04.07</u>		
Comment :	Est Rev:I 02.09.25 Rearranged procedure steps KJ Est Rev:J 06-03-23 As per Rev D JLM Est Rev:K 06-07.13 As per dsi9343 EC Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC Est Rev:M 08-04-22 update steps 4, 13 DD verified by:EC Est Rev:N 08-09-23 revF as per dwg DD verified by:ec Est Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JLD 09/04/23



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

8 09/04/23

2.0	D26003BENT	Extrusion Bent
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent,

Extrusion (Bent)

*B 45897**D M 9-4-13*

3.0	D2744	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch:

*B 44892**D M 9-4-13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47037

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod

9/4/09 M110676 DE 9-4-13

10-Grind welds flush as per Dwg D2750

9m' 09-04-13 (D)

12- Scribe batch# inside per dwg D2750

M 9-4-13

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/04/13 (X)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/13 (X)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M 9-4-13

W/O:		WORK ORDER CHANGES					
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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47037

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 9-4-13

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

Batch:

Handwritten: 647124, 1, H, 9-4-13

10.0

D34901

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch:

Handwritten: 45338, 2E, 9-4-14

11.0

D34903

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch:

Handwritten: 45560, 2E, 9-4-14

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch:

Handwritten: 44891, 2E, 9-4-14

13.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on
sheet 8)

Handwritten: H, 9-4-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47037

Part Number: D350636011

Job Number:



Seq. #: Machine Or Operation: Description :

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: M111031
exp. date: D-1-1

M 9-4-13

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 8)

A/R Aluminum Rod batch: M110972 BE 9-4-14

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

11-Deburr holes

- ARM 9-4-14

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

Sorlati 16 (X) ~~Sorlati 16~~ (X)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sorlati 16 (X) ~~Sorlati 16~~ (X)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

yes 09-04-20 (X1)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

M 110939

START TIME:

2:45

OVEN TEMPERATURE:

320°

FINISH TIME:

3:15

BR 09-04-21 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47037

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION
Inspect for foreign object per QSI 024

FL 09/04/22 ①

19.0

ALS41032225

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

* Insert

Batch:

m110118

FL

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
1- Install inserts as per Dwg D2750

FL 09/04/22 ①

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch:

B45556

FL

22.0

D37911

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch:

B45577

FL

23.0

D37931

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch:

B47024

FL

24.0

D37933

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch:

B45355

FL 09/04/22 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47037

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

D37941

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: B46530

FL

26.0

D37943

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: B46531

FL

27.0

D353525

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B45350

FL

28.0

D353625

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B45569

FL

29.0

D35371

Wearpad



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEARPAD

Batch: B46650

FL

30.0

D36311

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: B45353

FL

31.0

D3488041

Blade Fitting Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: B41853

FL 09/04/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47037

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

AN3C5A

Bolt



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Bolt

Batch: m111424

FL

33.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: m110372

FL

34.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: m110155 (x1) m110665 (x3)

FL

35.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: m110105

FL

36.0

AN960C10L

washer



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

washer

Batch: m111424

FL

37.0

AN960C816L

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Batch: m110139

FL

38.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: m110584

FL 09/04/22 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Tuesday, 07/04/2009 11:46:35 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47037

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

NUT

Batch: m110584

FL

40.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

Batch: m110450

FL

41.0

D34921

Plug



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Plug

batch: B46101

FL

42.0

NAS1611010

O-RING



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

O-RING

batch: _____

P10

43.0

D34923

Plug



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Plug

batch: B46102

FL

44.0

NAS1611013

O-RING



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

O-RING

batch: m111424

FL

45.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: _____

FL 09/04/22 P1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/04/22	42.0	Replace O-ring WAS1611-010 For O-ring D2594-3 x8 Batch: B29908	FL	09/04/22	8		S 09/04/22

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Date: Tuesday, 07/04/2009 11:46:35 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47037

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: m 11/087

EXP DATE: 10/20

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: m 101223

5-Coat all exposed fasteners with "LPS Procyon" batch: m 104251

FL 09/04/22 (1)

46.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 Oct 22 (10)

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

48.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: B45390

9/4/23

SP

49.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M110658 M110741

*****apply antiseize prior to packaging*****

Batch: M110658

9/4/23

SP

50.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M110139

9/4/23

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47037

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

51.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M108964

9/4/23

SD

52.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M111424

9/4/23

SD

53.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: 344917

9/4/23

SD

54.0

D35321

Spacer



Comment: Qty.: 2.0000 (s)/Unit Total : 2.0000 (s)

batch: 44904

9/4/21

SD

55.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*****ensure antiseize is on AN8C21A bolts*****

09/04/23

56.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-011

Rev G

09/04/23

57.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/24

Job Completion



47037

MF 09-04-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PORT HADLOCK, WA		
DRAWN			
CHECKED		DART AEROSPACE USA, INC.	
MFG. APPR.		DRAWING NO.	REV. F
APPROVED		D2750	SHEET 1 OF 11
DE APPR.		TITLE	SCALE
DATE	08.07.16	350 SKIDTUBE ASSEMBLY	NTS
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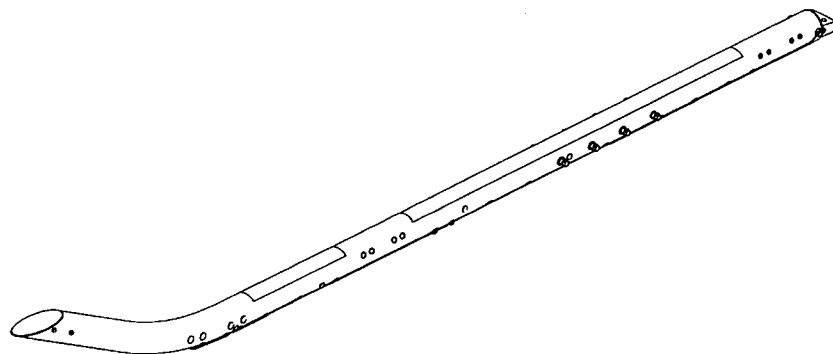
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

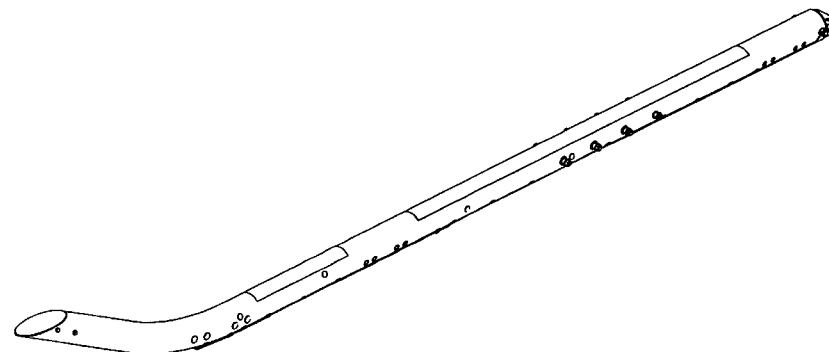
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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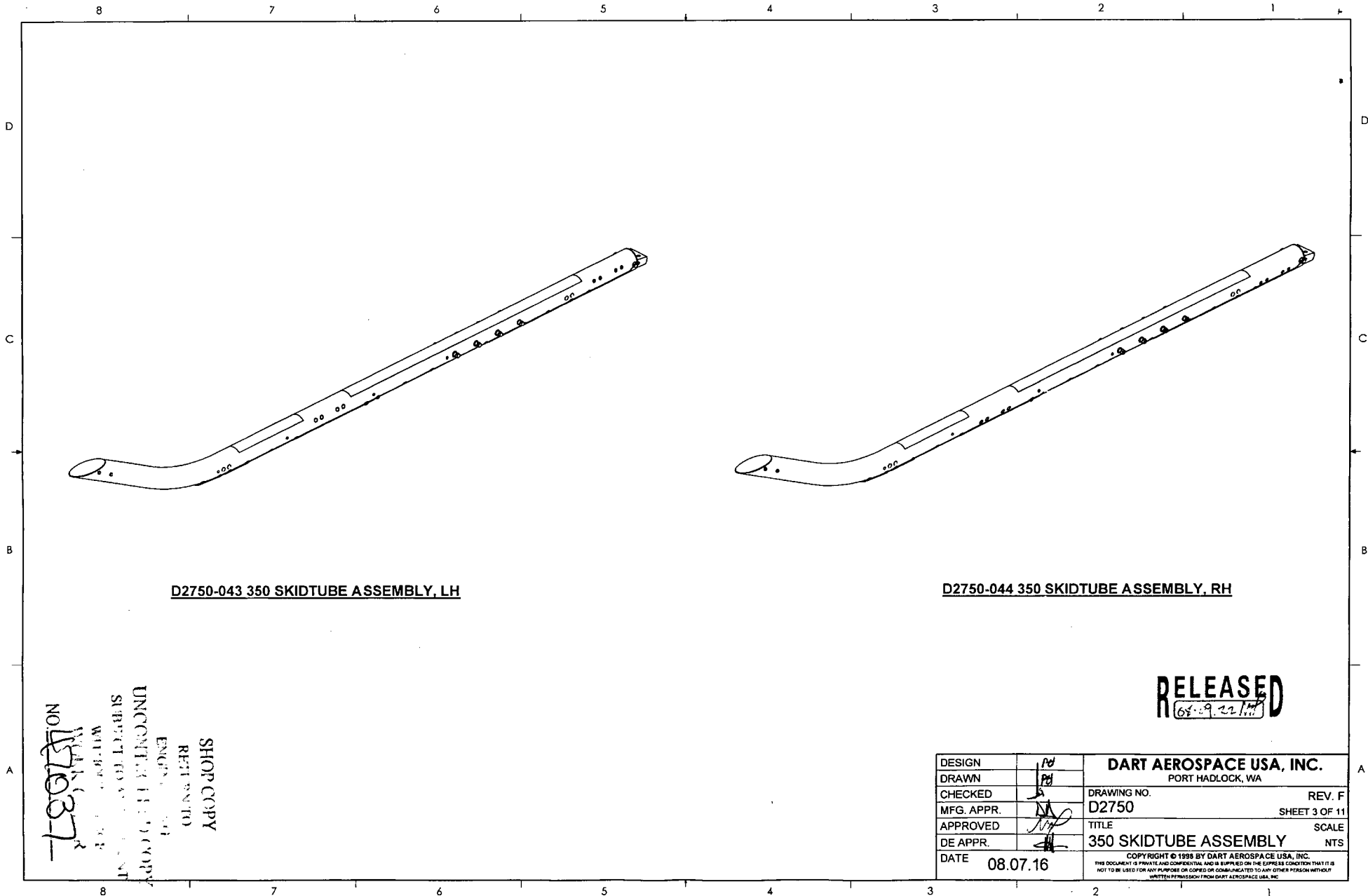
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



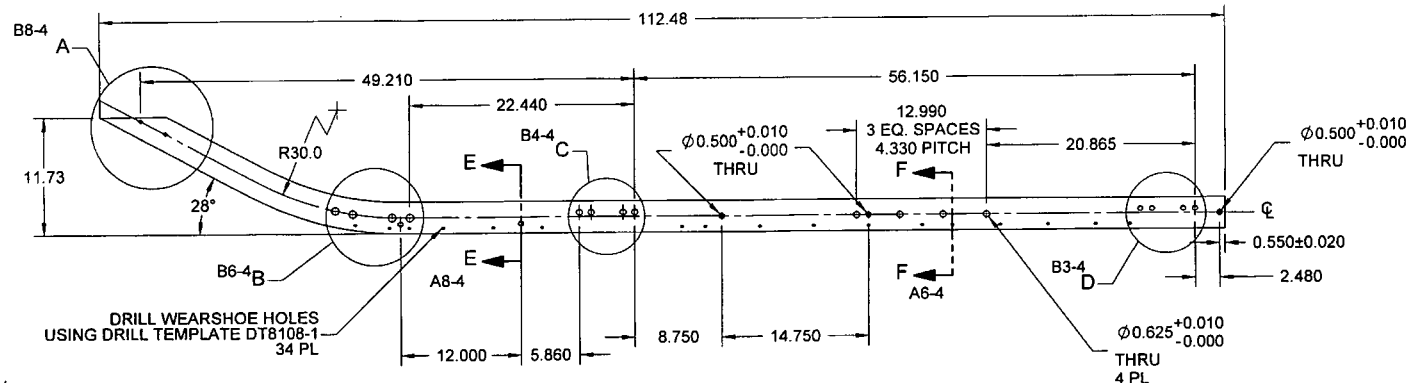
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D2750-044 350 SKIDTUBE ASSEMBLY, RH

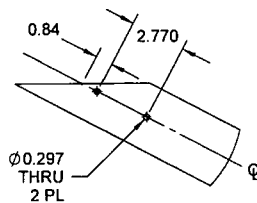
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MFG. APPR.	NA	SHEET 3 OF 11	
APPROVED	NA	TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
DE APPR.	NA	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	
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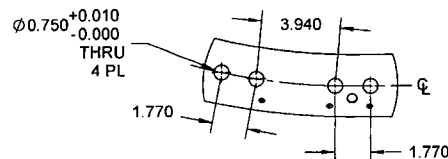


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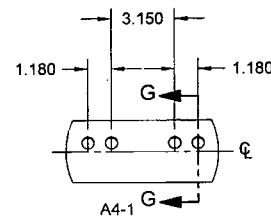
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SCALE 2X

D7-4



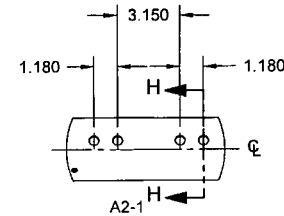
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D7-4



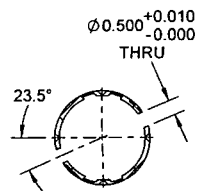
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D5-4



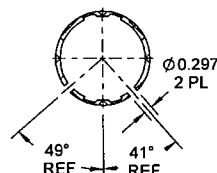
DETAIL D
SCALE 2X

D3-4



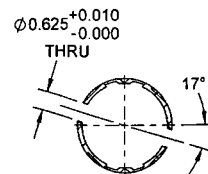
SECTION E-E
SCALE 3X, 2 PL

D6-4



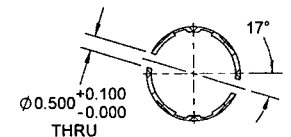
SECTION F-F
SCALE 3X, 17 PL

D4-4



SECTION G-G
SCALE 3X, 4 PL

B4-4



SECTION H-H
SCALE 3X, 4 PL

B2-4

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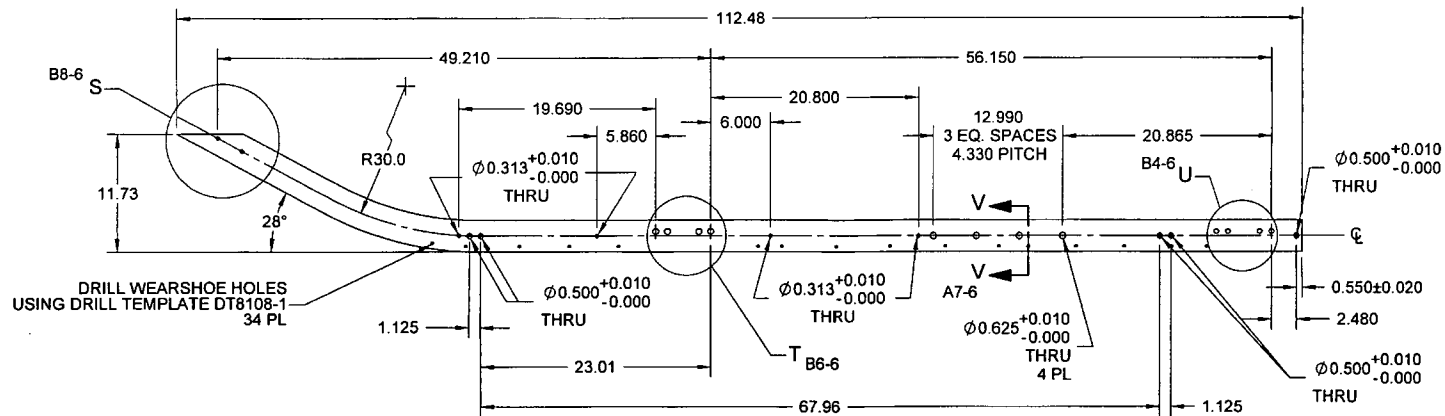
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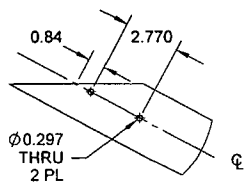
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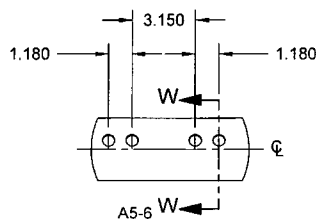
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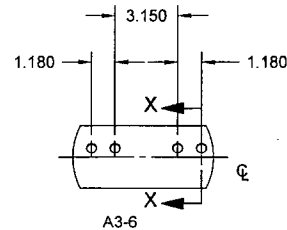
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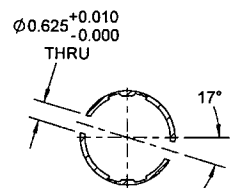
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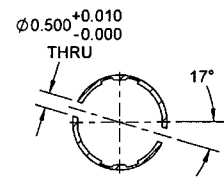
DETAIL T
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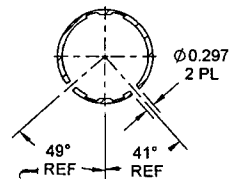
DETAIL U
SCALE 2X



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL



SECTION V-V
SCALE 3X, 17 PL

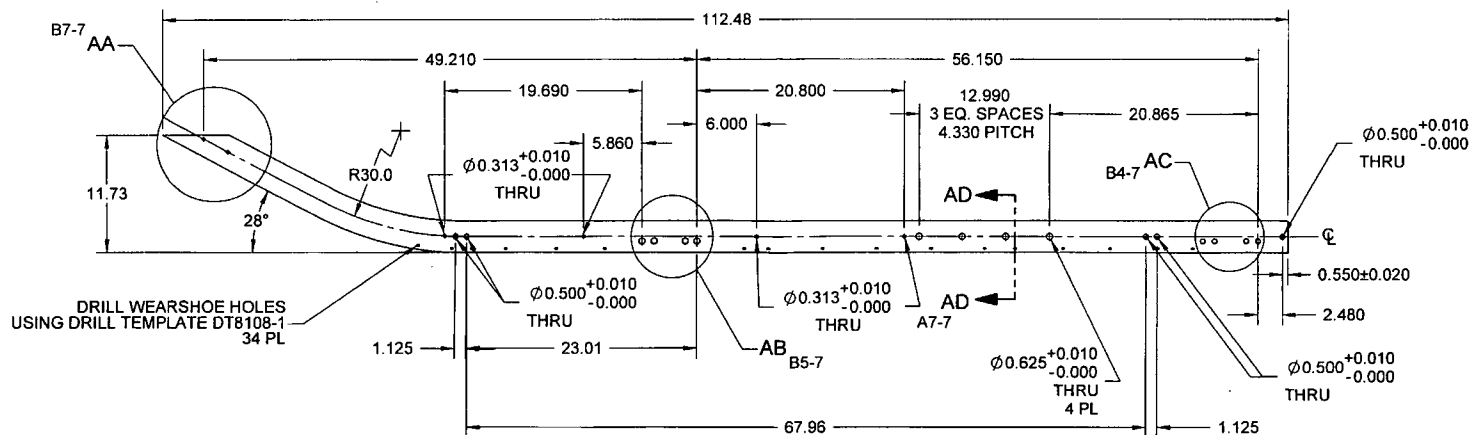
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DATE	08.07.16	SCALE NTS

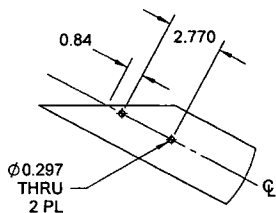
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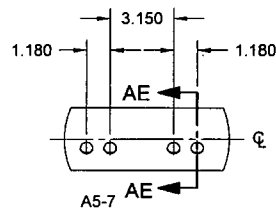
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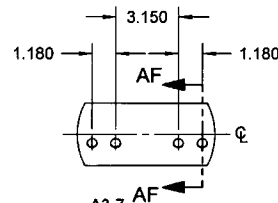
D2750-4 RH SKIDTUBE



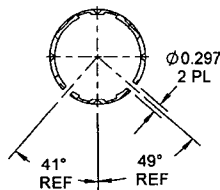
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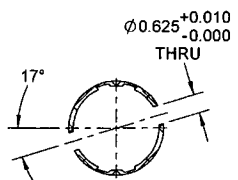
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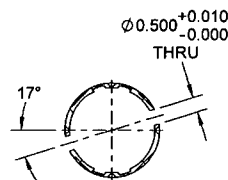
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



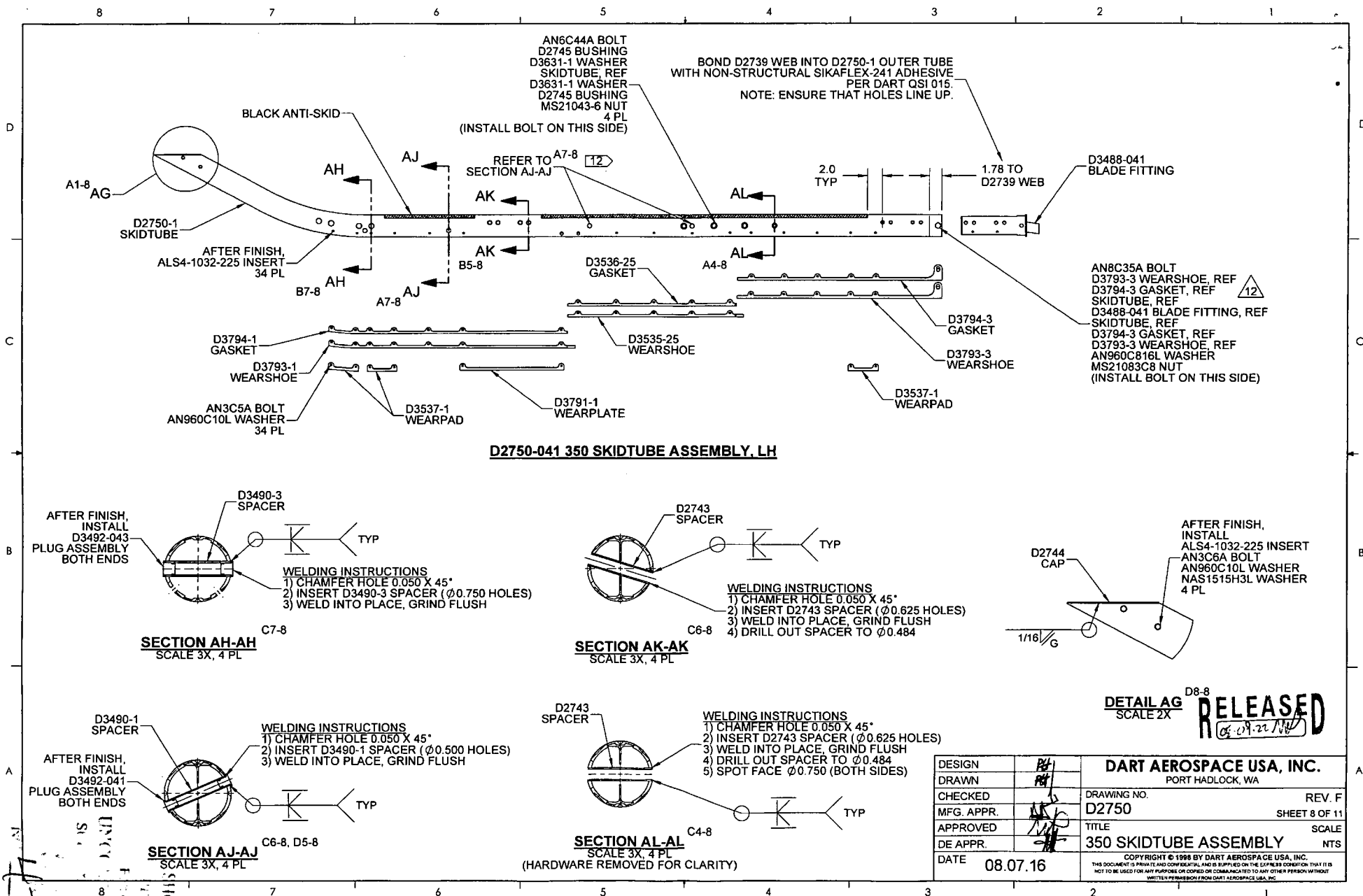
SECTION AF-AF
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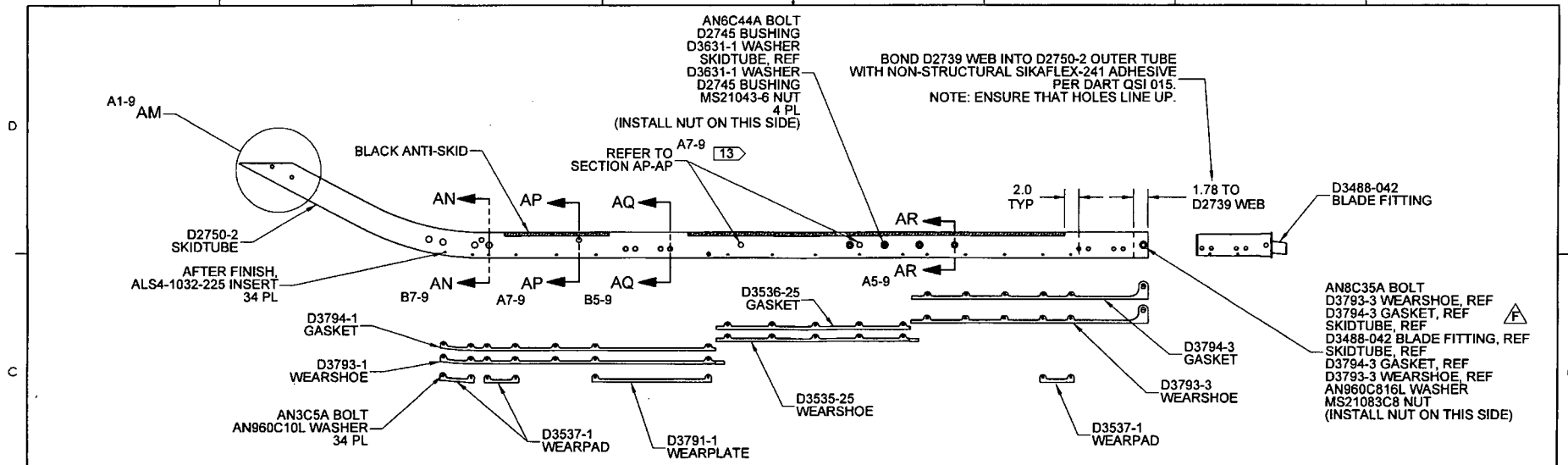
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MFG. APPR.		SHEET 7 OF 11	
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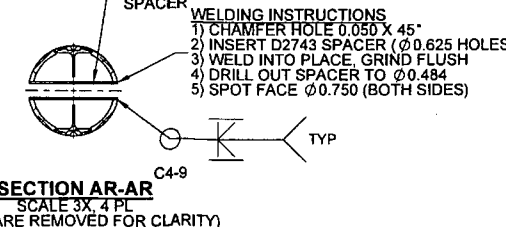
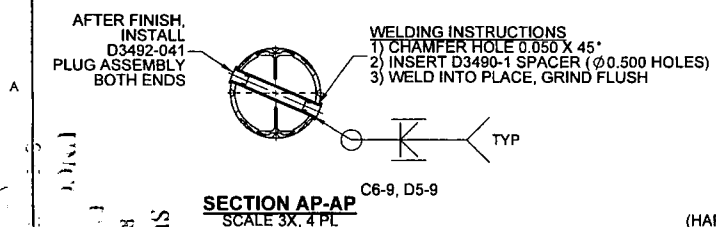
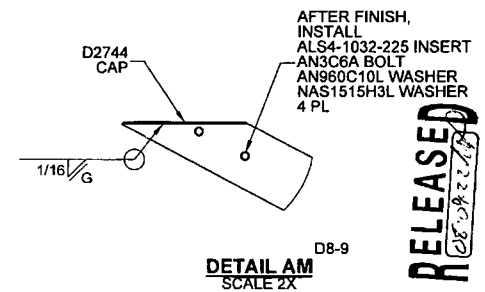
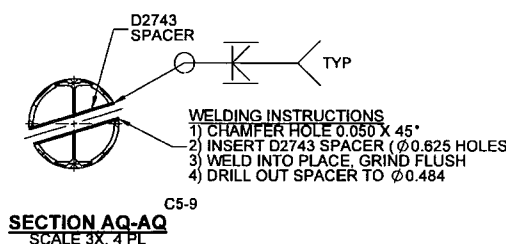
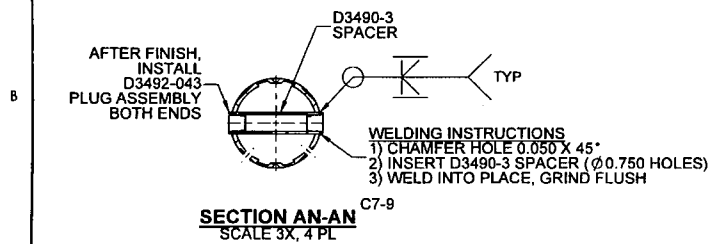
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D2750-042 350 SKIDTUBE ASSEMBLY, RH

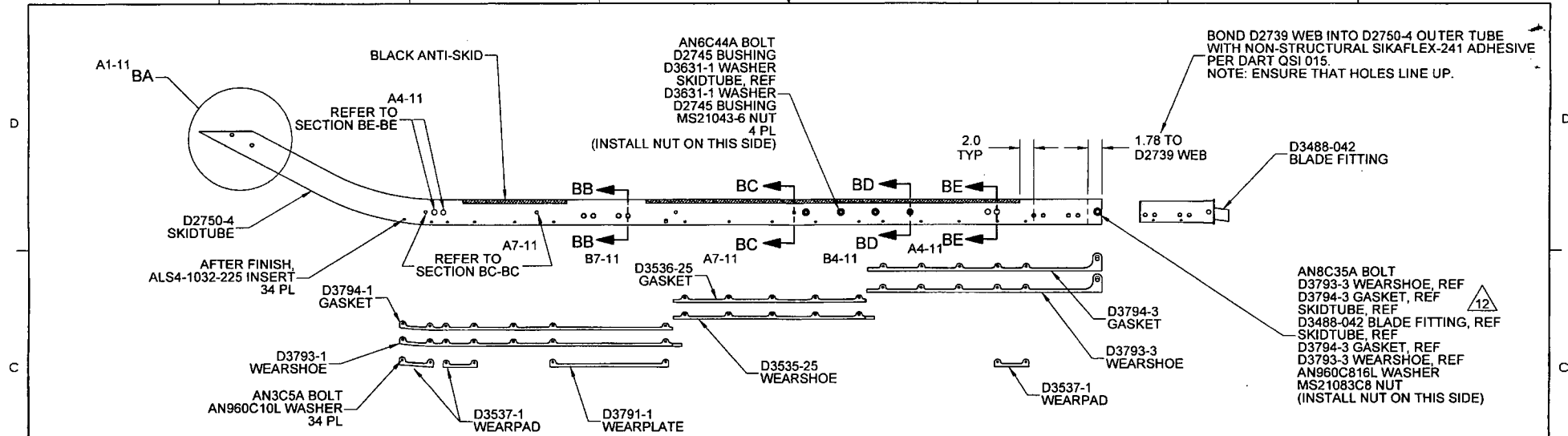


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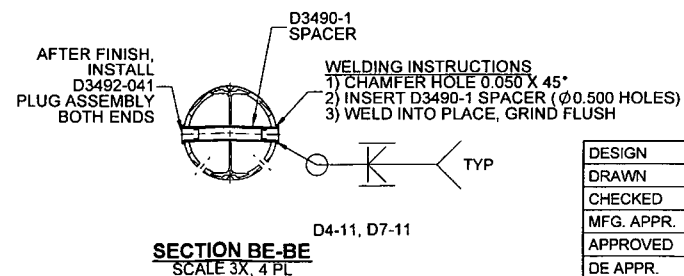
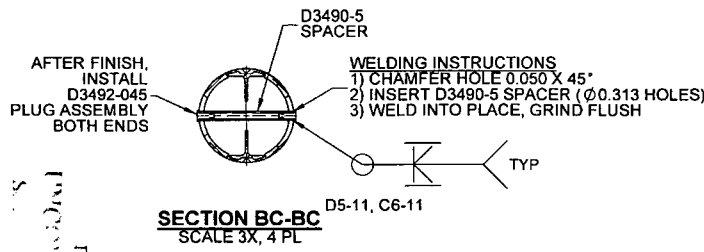
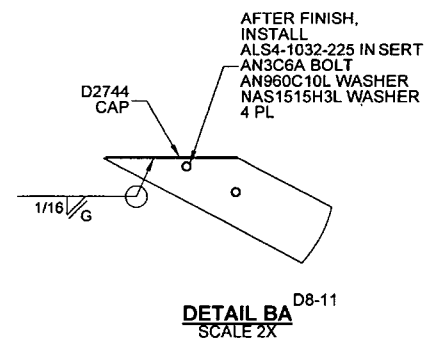
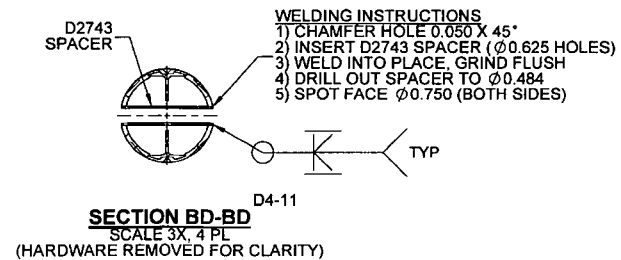
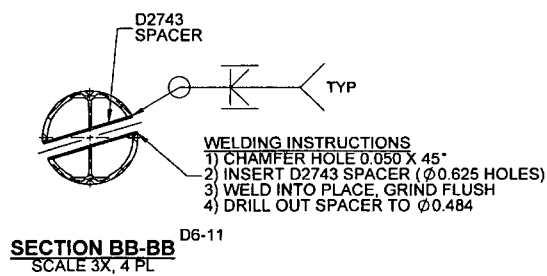
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D2750-044 350 SKIDTUBE ASSEMBLY, RH

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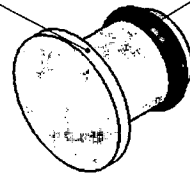


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D3492-XX PLUG
(SEE TABLE)

NAS1611 PLUG
(SEE TABLE)



D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

△ △ △







NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

~~UNDER REVIEW~~
07.04.05
OK ASS 08.11.12

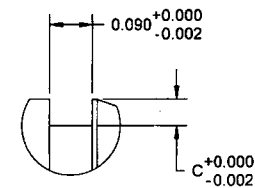
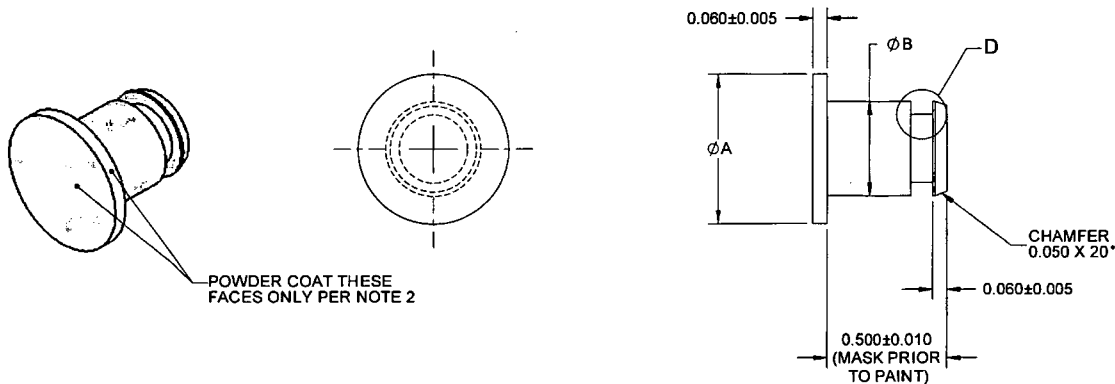
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07.10.05

C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPEATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750




NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

UNDER REVIEW
03.04.11
OK
13508.11.12
OK

DEO ATTACHED

RELEASED
07.11.16

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DRAWING NO. D3492	REV. C SHEET 2 OF 2
DATE	07.10.05	TITLE PLUG	SCALE 4:1
		COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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UNION COPY
STAMP

7 6 5 4 3 2 1

DRAWING NO. D3492	TITLE PLUG	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3492-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 08.11.05	DATE 08.11.05	DATE 08.11.05	DATE 08/11/05		DATE 08/11/05		

SHEET 2 MODIFY -13 PLUG AS SHOWN:

IS:

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.510	0.045	M6061T6R0.750

WAS:

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.520	0.045	M6061T6R0.750

RELEASED
08/11/10

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 TO
 47037

NO. 196

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 47005
Part number: D350 636 011
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier Patricia D. J. Date of Test Coupon 09-04-14
Welder Barclay Elliott Date of Test Coupon 09-04-14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld